

Work Order ID 118400

September-04-14 3:13:32 PM

118400

Page 1

Item ID: D119-646-212

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube with Run-on Landing Wearplates RH

Stop

NS2

Start Date: 9/04/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/12/14 Req'd Qty: 1.00

1

Customer:

Reference: REWORK RS1015

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D119-646

B

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP D119-646-212 CHG004

DAS
3
6-69

OCT 31 2014

101

0.00

101

Skidtubes

Skidtubes

Memo

0.00

PULL FROM STK:
1 X D119-646-212 B117377 CHG004

FWD GHW HOLES DO NOT ALIGN
REWORK PER RS1015

KEEP ORIGINAL KIT AND PUT ASIDE TO BE REPACKAGED ONCE
TUBE IS REWORED

DART		120-0000000000	
PATENT		US #5735484 / CA #2222184 / EURO #0828655	
P/N	D119-646-212	CHG	CHG004
DESC	Skidtube STD, RH	SIC	SR02024SE
LOT	B117377	SIC	
MODEL	Agusta A119/AW119MKII	SIC	
TD APPROVAL #09-09		MADE IN CANADA	
		02729-0	

B118400RH

14-9-5

Work Order ID 118400

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118400

Page 2

Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube with Run-on Landing Wearplates RH
Start Date: 9/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/12/14 Req'd Qty: 1.00 ***1*** Customer:
Reference: REWORK RS1015

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102		0.00							
102									
HandFinish	Memo	0.00							
Hand Finishing	REMOVE FWD AND AFT CAP -SET ASIDE TO RE-INSTALL CLEAN OFF SIKAFLEX								
103	QC5- Inspect part completeness to step on W/O	0.00							
103									
QC	Memo	0.00							
Quality Control									

DP 14-9-5

N/A

DP 14-9-5

Work Order ID 118400

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118400

Page 3

Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube with Run-on Landing Wearplates RH
 Start Date: 9/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/12/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK RS1015

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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104

104

Skidtubes

Skidtubes

Memo

0.00

1-DRILL OUT AND REMOVE CROSS BOLT SPACERS D2579 IN
 DETAIL C ON DWG D3887

2-REPOSITION LOCATION OF HOLES AS PER DWG BUT USING
 +/-0.005" TOL AND PER SYMMETRICAL IN QSI 018

3- TACK ONLY CROSS BOLT SPACERS D2579 B 113785 ²

4-REAM HOLES TO MAX TOLERANCE AS PER QSI018

5-TEST FIT GRD HANDLING FIXTURE

105

105

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

LOCATION MUST BE VERIFIED BY QC
 RECORD DIMS:

Filtered Soap

Stucco

105.1

Outsource - Send to IUT for paint stripping
 PO 25865

CL 14/09/22 ①

105.2

Receiving - Receive + Inspect

→ SP 14-10-14. 1X.

105.3

QC - QCB Schedules

Work Order ID 118400

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118400

Page 4

Item ID: D119-646-212 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube with Run-on Landing Wearplates RH
 Start Date: 9/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/12/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK RS1015

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106	*106* HandFinish Hand Finishing 106-1 -	0.00 0.00							
	<i>Replodine</i> Memo TOUCH UP ALODINE PER OSI005 <i>Repowder coat per OSI005</i>								
107	*107* QC Quality Control 108 Hand finishing - Reassemble using original parts 109 QC - QCS	0.00 0.00							
	<i>QC - Inspect Chemical Conversion Coat / powder coat</i> Memo <i>Reassemble using original parts</i>								
110	*110* Packaging Packaging	0.00 0.00							
	Pick Kit Memo ENSURE ORIGINAL KIT IS IN BOX								

DAS
41 14-10-24
9-89

DAS
38
9-89 14-10-24

DAS
38
9-89

OCT 31 2014

Work Order ID 118400

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118400

Page 5

Item ID: D119-646-212

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube with Run-on Landing Wearplates RH

Start Date: 9/04/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/12/14

Req'd Qty: 1.00

1

Customer:

Reference: REWORK RS1015

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
05
9-09

31-6

130

0.00

130

Packaging

Memo

0.00

Packaging

REPACKAGE USING NEW B/N

Identify and pack for shipping as per PPP D119-646-212

Location: 084

PPP rev: _____

DAS
05
9-09

OCT 31 2014

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14/11/3 J

4-10-31

Picklist Print

September-04-14 3:13:32 PM

Page 1

Work Order ID: 118400

118400

Parent Item: D119-646-212

D119-646-212

Parent Item Name: Skidtube with Run-on Landing Wearplates RH

Start Date: 9/04/14

Required Date: 9/12/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

12.09.12 as per ECN12-644 DD verf:JLM

IPP REV:C 12.11.05

raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to

chg004 (ECN 13-534) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-646-212

Manufactured

No

Each

5.0000

1

D119-646-212

Skidtube with Run-on Landing Wearplates RH

3117377

Location

Loc Qty

Loc Code

FG084

5

117613

1

117614

1

121123

1

121124

1

121125

1

14-9-5

DART AEROSPACE LTD		Work Order: 118400
Description: Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes		
Drawing: D3887	Repair Scheme:	RS1015
Part No: D119-646-241	Page:	1 of 1
Batch No:	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	DP	14-9-5	1
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	DP	14-9-5	1
3	Skidtube	Reposition location of holes as per Drawing but using <u>+/-0.005" tol</u> and per symmetrical in QSI 018	DP	14-9-5	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B <u>113785</u> v2	BR	14-09-05	1
5	QC	Location MUST be verified by QC Record Dims HERE Fitted 3g	S	14/09/08	
6	Skidtube	Weld as per QSI 004 A/R <u>M129399</u> Back Drill Grind welds flush & deburr	BR	14-09-08	1
			DP	14-9-8	1
7	QC	QC 10 & 5 Inspection ***TEST FIT GHW WHEELS*** Pass <input type="checkbox"/> Fitted 3g	S	14/09/08	
8	Finishing	Touch up alodine as per QSI 005	W	14/10/20	1
9	Finishing	Touch up Powder coat per QSI 005 <u>M129808</u> START: 2:10 TEMP: 320° FINISH: 2:40	DAS 38	14-10-20	1
10	Finishing	Re-assemble original caps back on tubes Sikaflex B <u>M1130227</u> exp <u>15/09</u>	DP	14/10/23	1
11	QC	QC 3 inspect	DAS 38 9-89	14-10-27	1
12	QC	QC 5 inspect	DAS 38 9-89	14-10-27	1
13	QC	QC21	DAS 38 9-89		

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.04.29	New Issue	ED		

U:\Admin\Forms\RepairschembIA.doc

Rev. A



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25865**

Purchase Order Date 9/22/2014

PO Print Date 9/22/2014

Page Number 1 of 3

Order From :

VC-IMI001

IMI MANUFACTURING INC.
772 MAIN ST. E.P.O. BOX 3
HAWKESBURY, ON K6A 2R4
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 613 675 1208 Ext.223

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						

1	118400	D119-646-212 Skidtube	9/22/2014 Yes 9/26/2014		1.00 ✓	\$50.00	\$50.00
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To cover the cost of pain stripping.
Strip product supplied.
B118400

Line Total: \$50.00

2	118401	D119-646-211 Skidtube	9/22/2014 Yes 9/26/2014		1.00 ✓	\$50.00	\$50.00
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To cover the cost of pain stripping.
Strip product supplied.
B118401

Line Total: \$50.00

8814-10-14-

Note:

9/22/2014



Manufacturing Inc.

2056 County Rd #4, L'Original, Ontario K0b 1K0

Phone 613-675-1208

Fax 613-675-1250

PACKING SLIP

TO : DART AEROSPACE
1270 Aberdeen Street
Hawkesbury ON
K6A 1K7

Date : October 14 2014

SALESPERSON:		JOB # 14-0464-22	PO NUMBER : 25865	
QTY ORDER		DESCRIPTION	QTY SHIP	LINE TOTAL
6	SKIDTUBE		6 ✓	1
SP 14-10-14				

Client: (PRINT NAME) _____ (SIGNATURE) _____

THANK YOU FOR YOUR BUSINESS!

New parts installed:

Part no:	Batch no:	Qty:
D2855-3	B111898	X2
D3632-1	B113581	X2
MAS1149C0-332R	M123306	X2
AN365A	M130358	X2
D3904-1	M133662	X16
AN3C-46A	M112899	X8
M521043-3	M1130673	X8
M524694-C52	M123059	X2

All installed by JH 11/10/22 (X1)

Work Order ID 118400

September-04-14 3:13:32 PM

118400

Item ID: D119-646-212

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube with Run-on Landing Wearplates RH

Start Date: 9/04/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/12/14 Req'd Qty: 1.00

1

Customer:

Reference: REWORK RS1015

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D119-646

B

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D119-646-212
CHG004

0.00

SD
label
X2 BLANC

1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7
TEL.: 1-613-632-5200 www.dartaerospace.com

PATENT		US #5735484 / CA #2222184 / EURO #0828655	
P/N	D119-646-212	CHG	CHG004
DESC	Skidtube STD, RH	STC	SR02024SE
LOT	B117377	STC	
MODEL	Agusta A119/AW119MKII	STC	

TC APPROVAL # 09-89 MADE IN CANADA D2729-4

ML5 1470-31

101

101

Skidtubes

Skidtubes

Memo

PULL FROM STK:
1 X D119-646-212 B117377

0.00

FWD GHW HOLES DO NOT ALIGN
REWORK PER RS1015

KEEP ORIGINAL KIT AND PUT ASIDE TO BE REPACKAGED ONCE
TUBE IS REWORED

14-9.5